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(11)

EP 0 894 533 A1

(12)

EUROPEAN PATENT APPLICATION

(43) Date of publication:
03.02.1999 Bulletin 1999/05

(51) Int. Cl.⁶: B02C 15/12, B02C 17/20,
B22D 25/02, B22D 19/00

(21) Application number: 97305766.4

(22) Date of filing: 31.07.1997

(84) Designated Contracting States:
AT BE CH DE DK ES FI FR GB GR IE IT LI LU MC
NL PT SE
Designated Extension States:
AL LT LV RO SI

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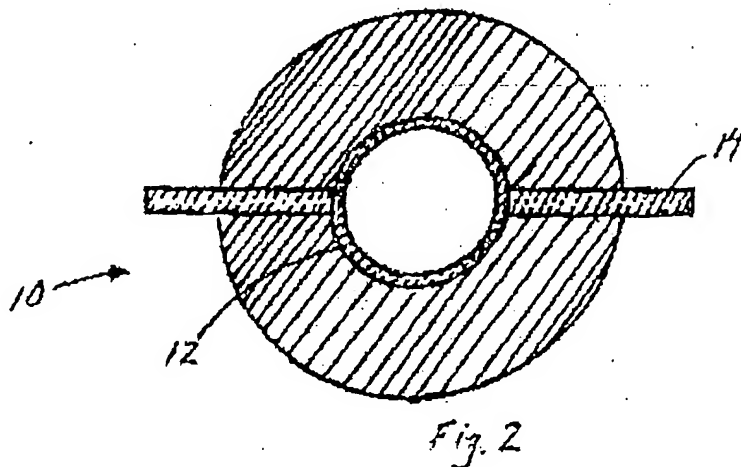
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(54) Metallic hollow cast balls and methods of casting

(57) A cast abrasion resistant hollow ball (10) is formed with a hollow ceramic core (12) that generates no gas during the casting operation. Solid ceramic bars or supports (14) hold the hollow ceramic core (12) in a fixed location at the centre of the cast ball (10) during the casting process. There are no open holes or open-

ings in the ceramic supports (14) due to the fact that the hollow ceramic core (12) is composed of an inert refractory material which eliminates any gases being generated during the pouring and solidification of the liquid metal in the casting process.



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Description

[0001] The present invention relates to metallic hollow cast balls and methods of casting such hollow cast balls.

[0002] Hollow metallic balls for pulverizer use have been known in which a core hole has been provided in the wall of the ball to discharge any gases evolved in the casting process. Ordinarily, the opening or core hole in the wall of the cast ball has generally been closed by means of a plug or the like.

[0003] US Patent No. US-A-3 254 849 relates to a cast hollow ball which utilizes a core that is consumed in the metal casting process. Gases evolved during the solidification of the metal within the mould escape from the interior of the ball through openings in the arms or radial pipe-like spokes. This patent teaches that the spokes or arms are advantageously hollow with both ends open so that the gases evolved during solidification of the metal will discharge through the hollow arms of the spider.

[0004] It is well known that pulverizer balls must be hollow to allow for the dissipation of compressive forces internally which prevent excessive breakage and service.

[0005] Still there exists a need for a process which solves problems associated with the prior art processes. These problems include the core moving due to ferrostatic forces acting thereon. Also, there is a problem with the possibility of fractures initiating at the supports that cause premature failure of the ball with the prior art process. There is a need for a process that eliminates the formation of gases in the interior of the casing which can impact the casting integrity and causing premature failure. Also there is a need for a process that eliminates the possibility of metal penetrating the centre core material which can contribute to an out-of-balance condition which eventually also leads to premature failure. Thus, there is a need for a new process for making cast abrasion resistant hollow balls and also a need for a cast abrasion resistant hollow ball which has a longer life than those previously proposed.

[0006] According to one aspect of the invention there is provided an article of manufacture comprising:

a metallic hollow cast ball having a hollow ceramic core situated therein, said hollow cast ball having at least one solid ceramic support situated therein extending outwardly from the hollow ceramic core to a wall of said hollow cast ball.

[0007] According to another aspect of the invention there is provided a method of casting an abrasion resistant hollow ball, the method comprising the steps of:

providing a hollow ceramic core;
holding the hollow ceramic core in a fixed location in a cast mould cavity;

pouring liquid metal around the hollow ceramic core without generating any gas when the hollow ceramic core is surrounded by the liquid metal; and allowing the liquid metal to solidify.

[0008] A preferred embodiment of the present invention is directed to solving the aforementioned problems associated with the prior art as well as others by providing a cast hollow ball which is cast on a spherical hollow ceramic core made from a highly refractory material such as fused silica (SiO_2) or other high temperature materials such as fused quartz or calcined alumina (Al_2O_3).

[0009] The preferred method of manufacture employs a hollow ceramic core which is placed into a mould cavity such as a sand mould cavity and has liquid (molten) metal poured around the core. The metal is allowed to solidify. The ceramic hollow core is supported by either a singular or plurality of solid ceramic bars or supports to hold it in a fixed location in the centre of the cast ball. If a plurality of bars are used, these would be located in a planar orientation and would support the hollow ceramic sphere on location and resist ferrostatic forces acting on the same. If a single ceramic support is employed, this would be oriented in a vertical plane and have attaching means on one end to attach the ceramic core to the support.

[0010] The preferred method advantageously uses a ceramic hollow core which is fired at a temperature in excess of about 1500°F (815°C) to eliminate any trace of organic materials to complete the bonding process, or a blown fused quartz hollow sphere with internal support members or arms. The blown fused quartz would not require a high temperature firing cycle. Also, the preferred method generates no gas when surrounded by the liquid metal during the solidification process. As such, the ceramic supports are solid and have no open holes in the ceramic support since the present technique is not concerned with venting any gas, as little or no gas is generated. There are no open holes in the ceramic supports due to the fact that the hollow ceramic sphere is composed of an inert refractory material which eliminates any gases being generated during the pouring and solidification process.

[0011] The resulting cast hollow ball is abrasion resistant, simple in design, rugged in construction and economical to manufacture.

[0012] The invention will now be described by way of example with reference to the accompanying drawings, throughout which like parts are referred to by like references, and in which:

Figure 1 is an exterior view of a hollow ball cast in accordance with an embodiment of the present invention;

Figure 2 is a sectional view of a hollow ball cast with two planar supports after the hollow ball has been cast but prior to removal of the excess refractory

supports; and

Figure 3 is a cross-section view of a hollow ball cast with a single vertical refractory bar which is threadably engaged into the hollow refractory sphere or core.

[0013] Hollow metal balls have been successfully used in the operation of a pulverizer of the general type shown in US Patent No. US-A-2 275 595. Embodiments of the present invention may have a similar use in these types of pulverizers. The ball typically has an exterior diameter of approximately 12-1/4 inch (310 mm) with a wall thickness of approximately 3-1/2 inch (90 mm) thick. Other hollow balls of varying exterior diameters may be made by such methods ranging from 6-1/2 inch (165 mm) or smaller to 40-1/4 inch (1025 mm) with metal wall thicknesses ranging from 1-1/4 inch (32 mm) to 10 inch (255 mm) thick. Of course, larger or smaller diameter balls having a greater or lesser thickness may also be cast with methods embodying the present invention. These balls are cast from highly abrasion resistant ferrous metals such as ASTM A32M-93A Class I to III or A128M-93 grades "A" to "F" and/or other suitable materials. These may be heat treated to obtain desired physical and metallurgical characteristics. The size of the balls is determined by the use for which they are intended and the balls may be used in other types of pulverizers or applications. Experience has shown that hollow balls as described herein, when heat treated for service in a pulverizer, resist impact stresses and heat effects better than solid balls formed from the same material and similarly heat treated.

[0014] In manufacturing a hollow ball 10 shown in Figures 1 to 3, a hollow ceramic core 12 is made from a highly refractory material such as fused silica for example or other high temperature ceramic materials. The ceramic core 12 is fired at temperatures in excess of about 1500°F (815°C) or a temperature high enough to eliminate any trace of organic material in the ceramic core 12. Advantageously, the present technique uses a ceramic hollow cast or blown core as opposed to the core material disclosed in US Patent No. US-A-3 254 849 which is a consumable core material and generates gases during the metal casting process. The present technique employs the hollow ceramic cast or blown core 12 which, when fired prior to the casting process, eliminates any trace of organic material and results in a core 12 which generates no gas when surrounded by the liquid metal during the solidification of the metal and the casting process.

[0015] Unlike the casting process disclosed in US Patent No. US-A-3 254 849, the present technique does not employ a consumable core material nor does it employ hollow arms as disclosed in that patent. Rather, the present technique advantageously produces an improved cast hollow ball which may be employed as a pulverizer ball as described in that patent, but the core material 12 in this case is a ceramic cast or blown

spherical hollow core 12 which uses at least one solid refractory bar or support 14. There are no openings or holes in the ceramic support 14 due to the fact that the hollow ceramic sphere core 12 is composed of an inert refractory material which eliminates any gases being generated during the pouring and solidification of the liquid metal during the casting process.

[0016] Figure 2 discloses a core 12 with two ceramic or refractory supports 14 fastened to the core 12 and which hold the core 12 in a fixed location at the centre during the casting process. In this manner, the core 12 is at the centre of the cast pulverizer ball 10. It will be understood that a greater or lesser number of refractory supports 14 can be used in the same plane or otherwise if necessary to support the core 12 so that it remains in the centre of the ball 10 during the casting operation. The present technique provides for at least one ceramic or refractory support 14 as shown in Figure 3 which is fastened such as by threadably engaging the ceramic core 12 or otherwise fixed thereto. When a single ceramic support 14 is employed, it is preferably oriented in a vertical plane to hold the ceramic core 12 in the fixed location in the centre of the cast ball 10.

[0017] The hollow ceramic core or sphere 12 is placed or held in a moulding cavity such as a sand mould cavity and liquid metal is poured or drawn, with or without the use of a vacuum, and is allowed to solidify around the ceramic core 12 in a casting operation as described in US Patent No. US-A-3 254 849, or by any other suitable casting operation. After the pulverizer ball 10 has been formed and solidified, the excess ceramic support 14 is removed, the pulverizer ball 10 is made flush and now may be heat treated or baked to obtain desired physical and metallurgical characteristics.

[0018] While specific embodiments of the present invention have been shown and described in detail to illustrate the application and principles of the present invention, it will be understood that the invention may be embodied otherwise without departing from such principles.

Claims

1. An article of manufacture comprising:

a metallic hollow cast ball (10) having a hollow ceramic core (12) situated therein, said hollow cast ball (10) having at least one solid ceramic support (14) situated therein extending outwardly from the hollow ceramic core (12) to a wall of said hollow cast ball (10).

2. An article of manufacture according to claim 1, wherein said metallic hollow cast ball is a pulverizer ball (10).

3. An article of manufacture according to claim 1 or claim 2, wherein said at least one ceramic support

comprises two solid ceramic supports (14) situated diametrically opposite each other in a planar orientation.

4. An article of manufacture according to claim 1, or claim 2, wherein said at least one ceramic support comprises a plurality of ceramic supports (14). 5
5. A method of casting an abrasion resistant hollow ball (10), the method comprising the steps of: 10
 - providing a hollow ceramic core (12);
 - holding the hollow ceramic core (12) in a fixed location in a cast mould cavity;
 - pouring liquid metal around the hollow ceramic core (12) without generating any gas when the hollow ceramic core is surrounded by the liquid metal; and 15
 - allowing the liquid metal to solidify. 20
6. A method according to claim 5, comprising the step of providing at least one solid ceramic support (14) attached to the hollow ceramic core (12) for holding the hollow ceramic core (12) in a fixed location so that it is at the centre of the cast ball (10). 25
7. A method according to claim 6, wherein the at least one solid ceramic support (14) is employed in a vertical plane for holding the hollow ceramic core (12) in the fixed location. 30
8. A method according to claim 6 or claim 7, wherein the at least one solid ceramic support comprises two solid ceramic supports (14) diametrically opposite each other in a planar orientation for supporting the hollow ceramic core (12) in a fixed location. 35
9. A method according to claim 5, wherein the hollow ceramic core (12) is supported by a plurality of solid ceramic supports (14) for holding the hollow ceramic core (12) in a fixed location. 40
10. A method according to any one of claims 5 to 9, wherein said hollow ceramic core (12) is made from a highly refractory material. 45
11. A method according to any one of claims 5 to 10, comprising the step of firing the hollow ceramic core (12) to a temperature to eliminate any trace of organic material and complete the bonding prior to the pouring steps. 50

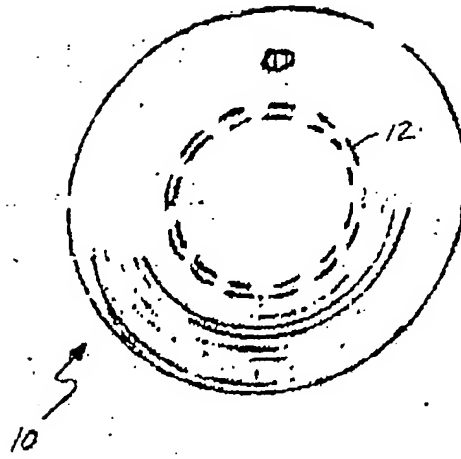


Fig. 1

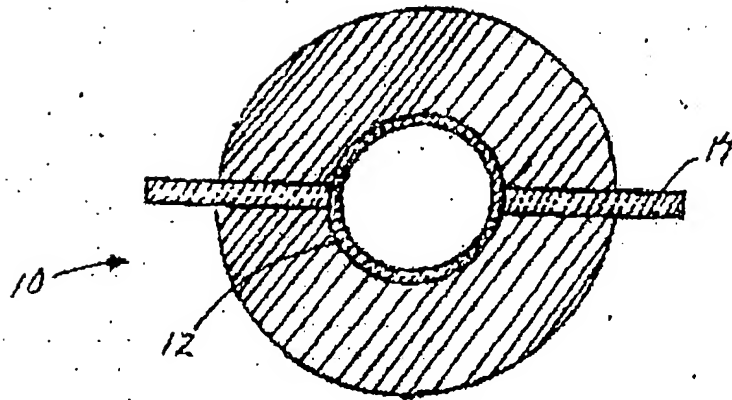


Fig. 2

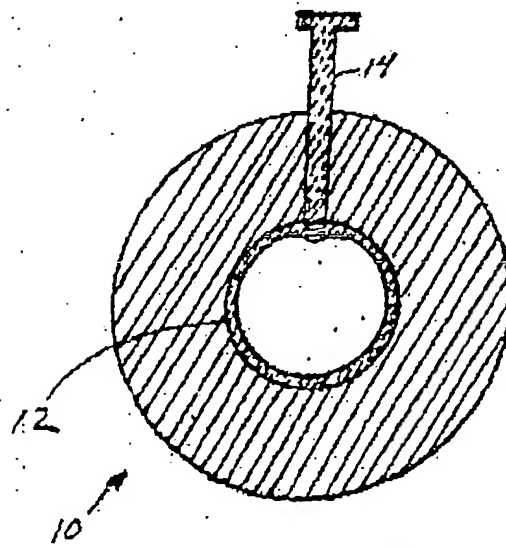


Fig. 3



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EUROPEAN SEARCH REPORT

European Patent
Office

Application Number
EP 97 30 5766

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
A,D	US 3 254 849 A (W.F.CLEMENTS) * the whole document *	1-11	B02C15/12 B02C17/20 B22D25/02 B22D19/00
A	DATABASE WPI Section Ch, Week 8007 Derwent Publications Ltd., London, GB; Class J02, AN 80-11856C XP002050899 -& JP 55 001 820 A (BABCOCK-HITACHI KK) , 9 January 1980 * abstract *	1-11	
A	US 1 934 239 A (A.A.SCHUPP) * the whole document *	1	
A	US 1 823 351 A (W.F.CLEMENTS) * the whole document *	1	
A	FR 675 153 A (P.M.ORET) * the whole document *	1	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
			B02C B22D
Place of search		Date of completion of the search	Examiner
THE HAGUE		19 December 1997	Mailliard, A
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